Dart Aerospace Ltd.

Date: Thursday, 4/5/2007 11:58:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31691
Estimate Number : 10198
P.O. Number : N/A
This Issue : 4/5/2007 **S.O. No.** : N/A
Prsht Rev. : NC
First Issue : N/A **Type** : SMALL /MED FAB
Previous Run : 31441
Written By :
Checked & Approved By : 07.04.05
Comment : Est E 04.06.09 Reformat KJ/RF
Est Rev:F 06-04-28 Manufactured on Water Jet JLM
Est Rev:G As per Rev E 06-11-22 JLM

Drawing Name : ANGLE
Part Number : D2175~~2~~-1 U
Drawing Number : D2175 REV E
Project Number : N/A
Drawing Revision : E
Material : N/A
Due Date : 4/30/2007 **Qty:** 30 **Um:** Each

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	M2024T3S063	2024-T3 .063 sheet

Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.063" thick
(M2024T3S.063) Batch: M103321 SAD 07/05/17 30

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D2175
Dwg Rev: E
Prog Rev: E
SAD 07/05/17 30
2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/05/17 30

4.0	QC8	SECOND CHECK

07.05.22 ㉚

Comment: SECOND CHECK counted.

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack SAD 07/05/23 ㉚

Dart Aerospace Ltd

W/O:		**WORK ORDER CHANGES**					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes [✓ No] **DQA:** ______ **Date:** 07/05/25

QA: N/C Closed: _____ **Date:** ________

NCR:		**WORK ORDER NON-CONFORMANCE (NCR)**						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Thursday, 4/5/2007 11:58:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: ANGLE

Job Number: 31691
Part Number: D2175~~2~~2-1

Job Number:

Seq. #:	Machine Or Operation:	Description :	
6.0	BRAKE NC	NC BRAKE	PTC
	Comment: NC BRAKE Form as per Dwg D2175	SB 07/05/23	41
7.0	QC5	INSPECT WORK TO CURRENT STEP	
	Comment: INSPECT WORK TO CURRENT STEP	07.05.24	41
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	FL / BR 07/05/24	41
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
	Comment: INSPECT CHEMICAL CONVERSION COAT	07/05/24	41
10.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_______	07/05/24	41
11.0	QC21	FINAL INSPECTION/W/O RELEASE	41
	Comment: FINAL INSPECTION/W/O RELEASE	07/05/25	

Job Completion

07.05.25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
07-05-23	6.0	Parts were bent as -1, operator error, did not focus on what side, and bent the whole stack	05/04/2	This W/O is now Qty 40, as -1, from W/O 31690	07-05-23	07-05-23	05/04/2	07-05-23

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DART AEROSPACE LTD		**Work Order:**	31691
Description: Angle		**Part Number:**	D2175-1-2
Inspection Dwg: D2175	**Rev:** E		**Page 1 of 1**

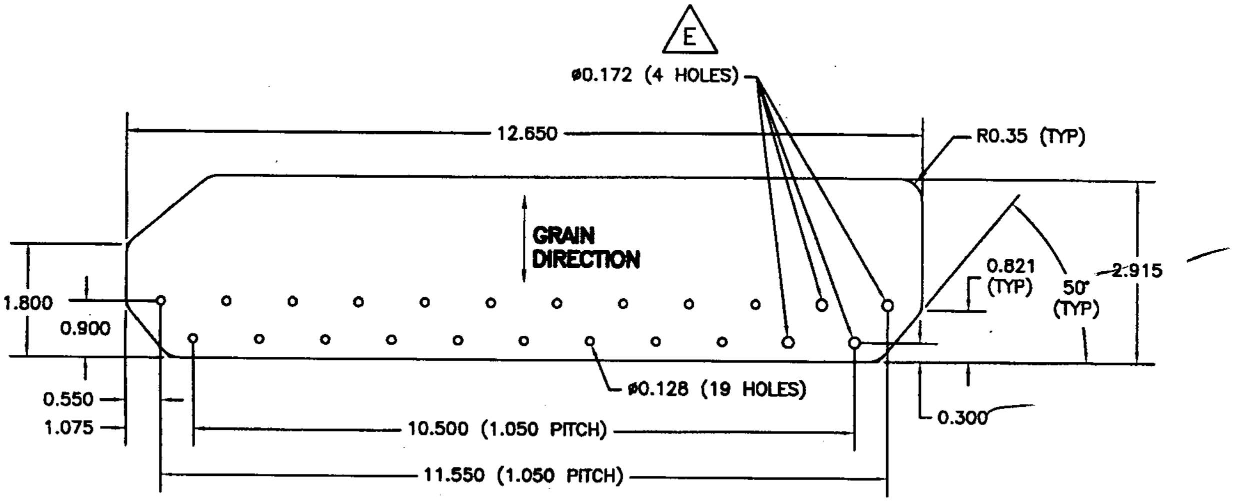
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

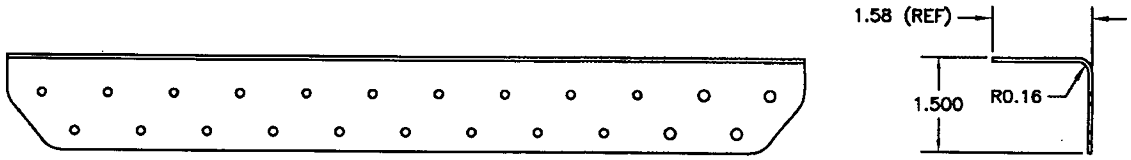
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		M-T / Vern	
R0.35	+/-0.030	R-0.35	✓		R-G	
2.915	+/-0.010	2.922	✓		Vern	
50°	+/-0.5°	50°	✓		~~Angle~~ Bevel Protractor	
0.300	+/-0.010	0.304	✓		Vern	
1.050 Pitch	+/-0.010	1.052	✓		Vern	
10.500	+/-0.010	10.501	✓		Vern	
11.550	+/-0.010	11.551	✓		Vern	
0.550	+/-0.010	0.547	✓		Vern	
0.900	+/-0.010	0.9041	✓		Vern	
0.063 thick	+/-0.010	0.061	✓		Vern	
Grain Direction	N/A		✓			
Ø0.128	+0.005/-0.001	Ø0.130	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.173	✓		Vern	

Measured by:	SAD	**Audited by:**		**Prototype Approval:**	N/A
Date:	07/05/17	**Date:**	0705-22	**Date:**	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	



D2175-1F FLAT PATTERN



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 3169

RELEASED
06 10 13

NOTES:
1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN RF	DRAWN BY	DRAWING NO. D2175
CHECKED PH	APPROVED	REV. E SHEET 1 OF 1
DATE 06.09.25		TITLE ANGLE
		SCALE 1:3

A	95.10.25	NEW ISSUE
B	96.01.18	CHANGED DIMENSION
C	00.09.11	UPDATE FINISH SPEC
D	04.06.03	RE-DESIGN
E	06.09.25	INC HOLE DIA TO ø0.172, 4 HOLES